

Date: Friday, 07/12/2007 7:42:50 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	WEARPLATE
<b>Job Number</b> :	36173		
<b>Estimate Number</b> :	10750		
<b>P.O. Number</b> :		<b>Part Number</b> :	D33156
<b>This Issue</b> :	07/12/2007	<b>Drawing Number</b> :	D3315 REV. B
<b>Prsht Rev.</b> :	NC	<b>Project Number</b> :	N/A
<b>First Issue</b> :	/ /	<b>Drawing Revision</b> :	B
<b>Previous Run</b> :	33333	<b>Material</b> :	
<b>Written By</b> :		<b>Due Date</b> :	24/12/2007
<b>Checked &amp; Approved By</b> :		<b>Qty:</b>	6 Um: Each
<b>Comment</b> :	Est: A 05.05.12 New issue KJ/JLM Est Rev:B As per Rev B 06-03-24 JLM Est Rev:C Now on Waterjet 07-07-11 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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**Comment:** Qty.: 2.1000 sf(s)/Unit Total: 12.6000 sf(s)  
 1010/1025/A21/6aA SHEET .060" THK  
 BATCH: 105706 RB 07-12-10

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3315  
 Dwg Rev: B RB 07-12-10  
 Prog Rev: B

2-Deburr if necessary RB 07-12-10

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

5 21/10 (16)

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B RB 08/01/11

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 07/12/2007 7:42:50 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36173

Part Number: D33156

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/01/11 (+6)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-6T3 as per QSI 004 and Dwg D3315 Rev: B

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

Batch M107553

Prop 30 min

8.0

QC10

+QC5

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/06/09 (+)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M10 5642

M. 08/06/09

09/06/2008

S.297 10.13

#1 321.6 F

#2 B36173 F

#3 D33156 F

#4 D33156 F

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

08/06/09 (+)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-6, B/N: BXXXXX

For Product Eligibility see PDA04-17

and Stock

Location: 493

8/6/09

SP

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10

Job Completion



08-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

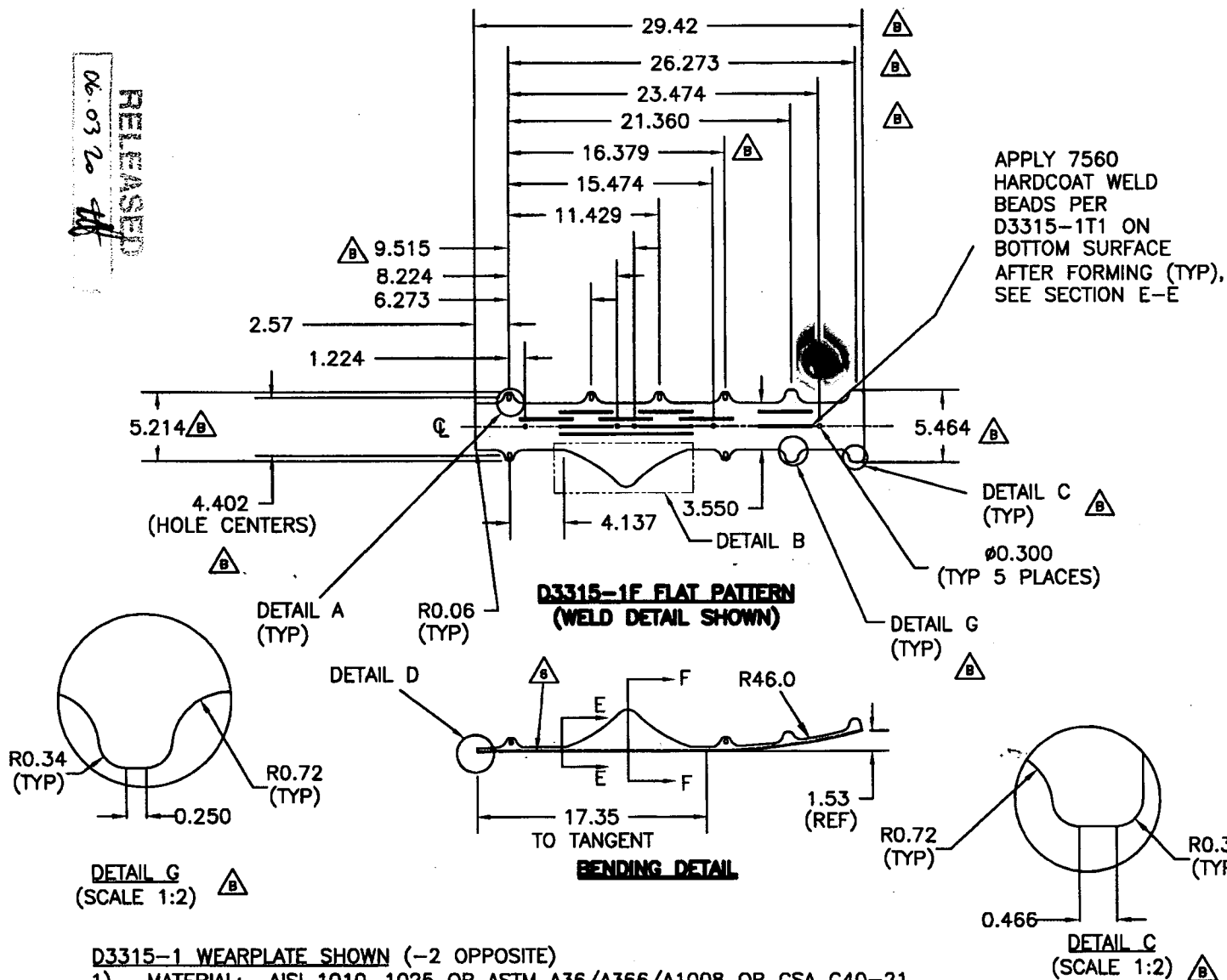
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
84	84		
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3315	SHEET 1 OF 4
DATE	TITLE		
06.01.31	WEARPLATE		
A	04.09.10	NEW ISSUE	
B	06.01.31	UPDATE DIMENSIONS	



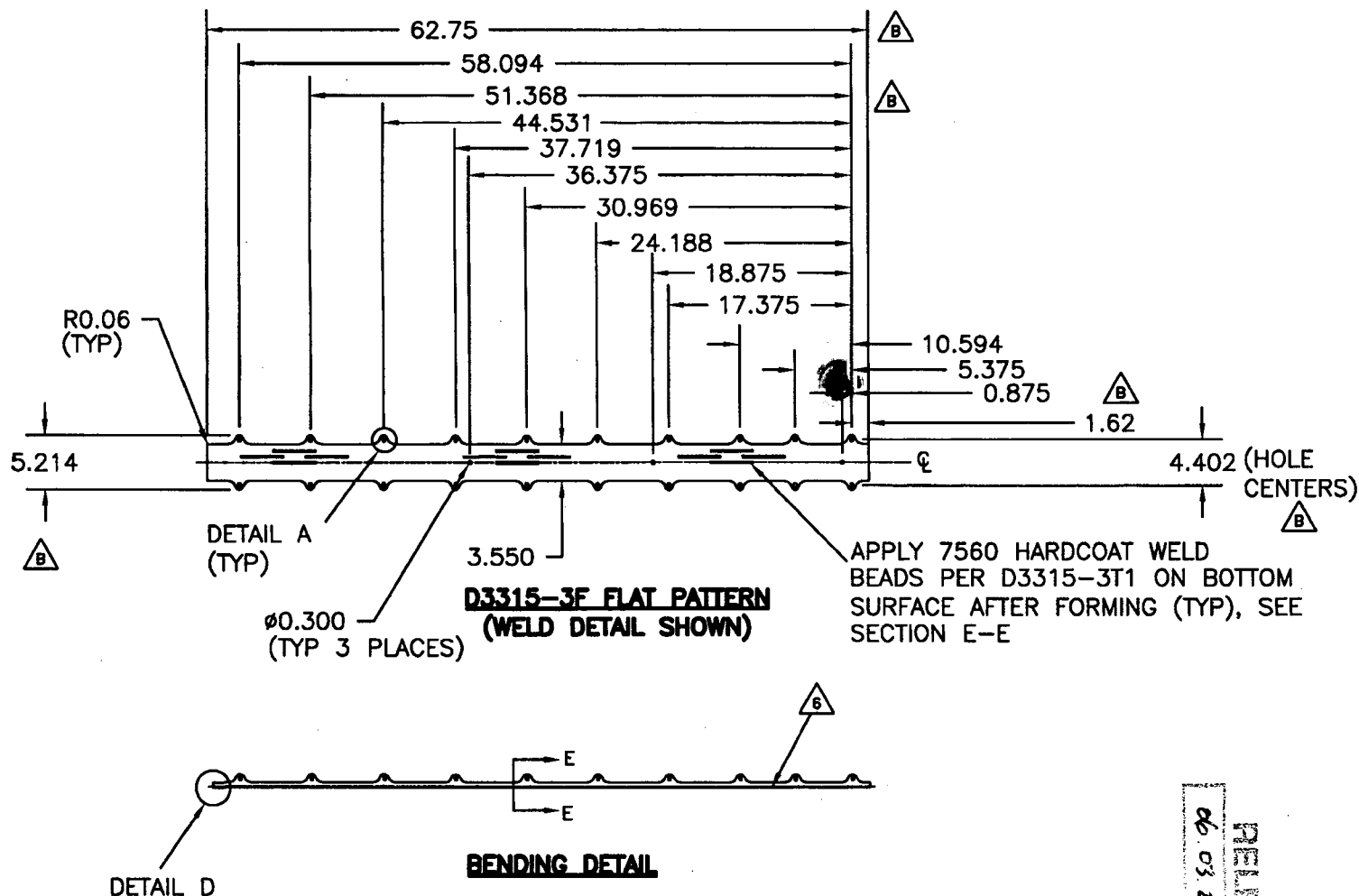
D3315-1 WEARPLATE SHOWN (-2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,  
38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

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RE-ASSED  
06.03.20  
AK

**DART**





**D3315-3 WEARPLATE SHOWN (-4 OPPOSITE)**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X  
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

RELEASED  
26 03 20

DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.31	TITLE	D3315	REV. B
		WEARPLATE		SHEET 2 OF 4
				SCALE 1:16

DESIGN	84	DRAWN BY	84	<b>DART AEROSPACE LTD</b> HAMKESBURY, ONTARIO, CANADA		REV. B
CHECKED		APPROVED		DRAWING NO.	D3315	SHEET 3 OF 4
DATE	06.01.31			TITLE	WEARPLATE	
					SCALE	1:12



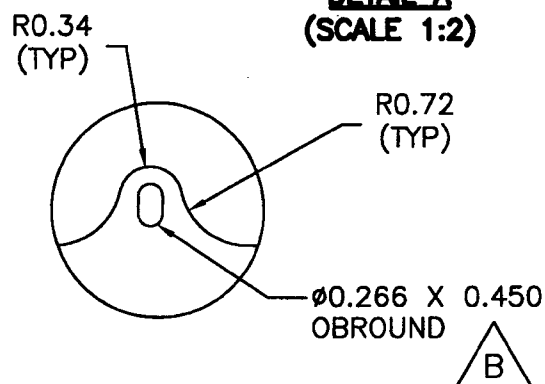
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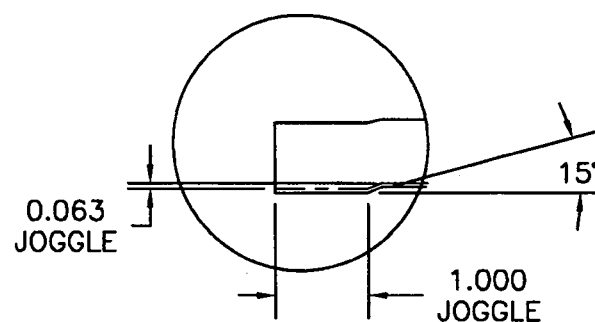


DESIGN	84	DRAWN BY	84	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED		APPROVED		REV. B
DATE	06.01.31	TITLE	WEARPLATE	SHEET 4 OF 4
				SCALE
				NIS

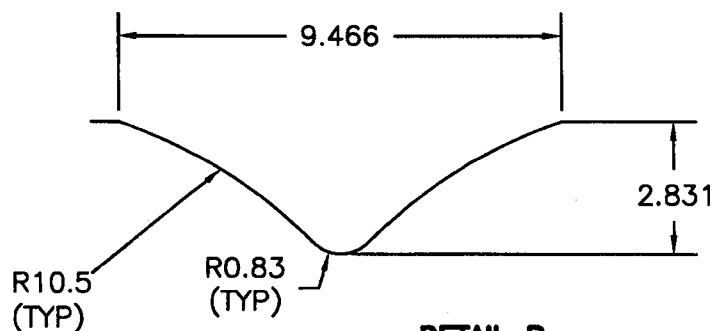
**DETAIL A**  
(SCALE 1:2)



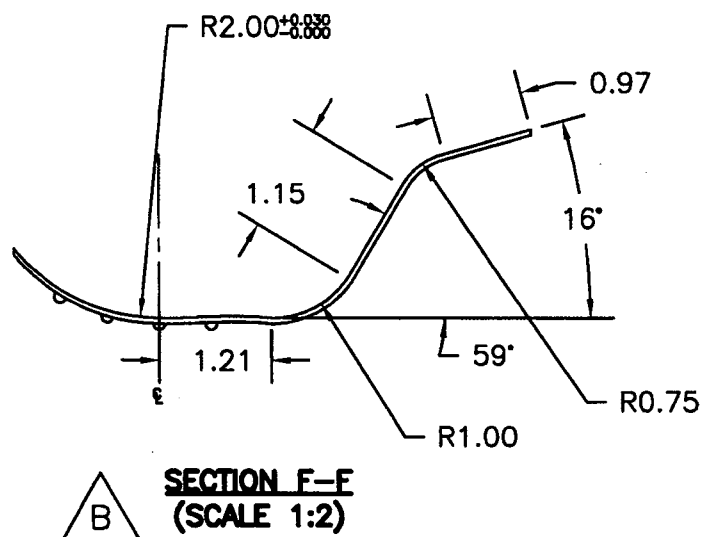
**DETAIL D**  
(SCALE 1:2)



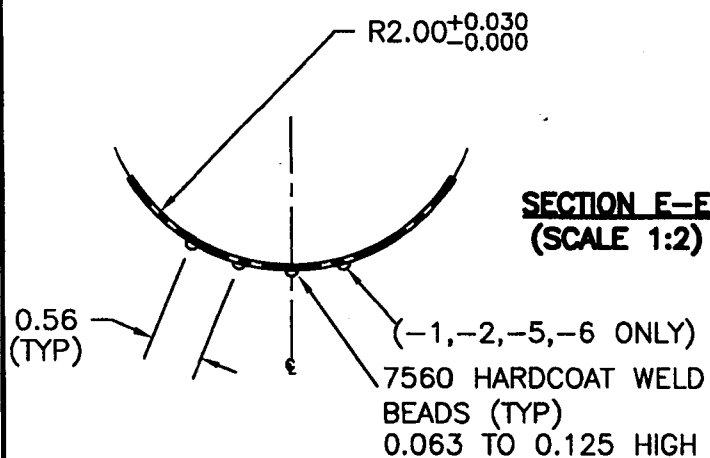
**DETAIL B**  
(SCALE 1:4)



**SECTION F-F**  
(SCALE 1:2)



**SECTION E-E**  
(SCALE 1:2)



06.03.20



DART AEROSPACE LTD		Work Order: 36173
Description: WEAR PLATE		Part Number: D 3315-6
Inspection Dwg: D3315-6 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .300	+ .002 - .001	.302				
.266	+/- .010	.268				
.456	+/- .010	.451				
.266	+/- .010	.268				
.575	+/- .010	.575				
3.550	+/- .010	3.554				
5.214	+/- .010	5.208				
5.464	+/- .010	5.464				
4.527	+/- .010	4.524				
4.402	+/- .010	4.406				
3.861	+/- .010	3.861				
6.465	+/- .010	6.465				
12.815	+/- .010	12.815				
14.735	+/- .010	14.735				
16.026	+/- .010	16.026				
17.965	+/- .010	17.965				
21.611	+/- .010	21.611				
24.215	+/- .010	24.215				
30.215	+/- .010	30.215				
34.31	+/- .030	34.31				

Measured by: IB
Date: 07-12-16

Audited by: J
Date: 7/12/10

Prototype Approval: 12/
Date: 7/12/10

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

